Ceb Sm

January-15-14 1		1304		*111!	n()4*						Page 1
Revision ID:	D3575-5	otostor	4	Accept	*N900	040	100)* s	Setup Sta Sto	1.71	S1* S2*
	Cargo Floor Pr 1/15/14 1/15/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				* "IN	5/°
	Process Plan	n: MP/MUJ	Date: 14.01.16	Tooling: SPC (Y/N):		ate:	-	F	Run Sta Sto	~ ~ 1\ 1	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr		A							
D3575	Rev	A									
*100 *100* Waterjet FLOW CNC Waterjet	et	FLOW WATER JET Memo 1-Cut as per Deburr if nea	Dwg D3575 Dwg Rev:_ cessary	0.00 0.00 A Prog Rev:	2-				c	<u> </u>	<u>JM14-07-3</u>
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							
110 QC Quality Control		Memo		0.00					_ 0_		<u>Jm14-</u> 02-
120 *1		QC8- Inspect parts - seco	and check	0.00 PAS 0.00 141213				<u>]</u>	· · · · · · · · · · · · · · · · · · ·		

DQA:			Date:										7	$TQ \wedge C^2$
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDA	NTE				AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	\Box	
			·			DISPOSITION			Α	AGAINST DE	PARTMENT,	PROCESS		
Work Order	r: _						ıl		cuit to be Co		1	Water Jet	_	Fasinassina [7]
Down No	_					Rework		ł	⊢	rosstube mall Fab	Dro	d. Eng. Coor.	\dashv	Engineering Quality
Part No	^{0.} –				_	Scrap Use-as-is	1		~ <u>~</u>	Finishing		e/Packaging	\dashv	Other
NCR N	0.					Suspected Unapproved		1110111	· —	mposite	1100,000	Supplier	\dashv	H
	_				_		'		• Ш	,				
Root					Desci	ription of work order update	ı	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification		QC Inspector
Design														
Doc/Data	_	ļ												
Equip/Tooling														
Handling/Pre	4													
Material	_						ļ							
Operator	4	1												*
Offset/Setup	4													
Process	_													
Supplier	4													
Training	4													
Transport	4													
Unapproved]				<u></u>						L_	
			- · · · · · · · · · · · · · · · · · · ·				FA	ULT CA	TEGORY					
Landin						General Bend]	Program		Outside Dim	onsians [٦	ressure/Forced
-		Bending Centre No	t Canaan		\vdash	BOM/Route	\vdash	Grain	rogram		Over/Under) -		et-up
		centre No Cracks	it Concer	itric	-	Broken/Damage/Defect	\vdash	Hardwa	250	-	Part Incorred	⊢	_	en-up emperature/Cure
	_	rimp/Kin	k/Binnlo	Mayo	-	Burrs	-	4	ire ion Incomplete/Unqual	lified	Part Lost/Mi		_	Veld
		Cuffs	k/ Kibbie	/ wave	-	Contamination	-	1	tions Incomplete/Uncle	<u> </u>	Part Moved	331118		Vrong Stock Pulled
	_	Crushing			-	Countersink	\vdash	4	gned/off center	-	Positioned V	Vrong L	'`	arong Stock runeu
	_	leat Trea	t		-	Cut Too Short	\vdash	Mislabe	-		Power Loss/		\neg	ther
-	_	nspection		Tuhe		Drawing	\vdash	Misrea]. 04.01 0033/			
	_	Marks/Ch	=	· unc		Drill Holes		Off-set						
	_	Furning So			-	Finish		-1	Calibration					
	_	Nave/Tw				Fit/Function		-	Sequence					

Work Ord January-15-14				*111504*								Page 2
Item ID: Revision ID: Item Name:	D3575-5 Cargo Floor	Protector		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	1/15/14 : 1/15/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:	_		_	S4 - 4		
Approvals:	Process Pl	lan:	Date:	Tooling:	Da	ite:	_		Run	Start	*N	R1*
	QC:	***	Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center I 130 *1_20* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburr if no	oce sary.	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
140		QC5- Inspect part comp	leteness to step on W/O	$\mathcal{M}_{\sim 00.0}$								
140 QC Quality Control		Мето		0.00								

Identify as per dwg & Stock Location:____

Memo

150

150 Packaging

Packaging

DQA: Date:			
	WORK ORDER NON-CO	ONFORMANCE / UPDATE	AEROSPACE
QA Closed: Date:			Work Order update only
Work Order:	DISPOSITION	AGA	AINST DEPARTMENT/PROCESS
work Order.	Rework	Skid-tube Cross	stube Water Jet Engineering
Part No.	Scrap		Il Fab Prod. Eng. Coor. Quality
1 dic No.	Use-as-is	1 ~—	shing Rec/Store/Packaging Other
NCR No.	Suspected Unapproved	Large Fab Comp	
Root Descr	iption of work order update	Initial Action	Sign &
Cause Date Step Qty	or non-conformance Ch	hief Eng Description	Date Verification QC Inspector
Design			
Doc/Data			
Equip/Tooling			
Handling/Pre			
Material			
Operator			
Offset/Setup			
Process			
Supplier			
Training			
Transport			
Unapproved			
		AULT CATEGORY	
Landing Gear	General	7- 1. /5	
! H ` H	Bend Bond Bond	Folio/Program	Outside Dimensions Pressure/Forced
	BOM/Route	Grain	Over/Under tolerance Set-up
. — —	Broken/Damage/Defect	Hardware	Part Incorrect Temperature/Cure
	Burrs	Inspection Incomplete/Unqualified	
 	Contamination Countersink	Instructions Incomplete/Unclear	Part Moved Wrong Stock Pulled Positioned Wrong
Heat Treat	Cut Too Short	Misaligned/off center Mislabeled	Power Loss/Surge Other
	Drawing	Misread	Lower ross/surge Other
	Drill Holes		
		ICOTT-SQT	
	Finish	Off-set Out of Calibration	

Work Orde		1504		*111	504*						Page	3
Item ID: Revision ID: Item Name:	D3575-5 Cargo Floor	Protector		Accept	*N900	040	100)* s	etup Sta	**	31* 32*	
Start Date: Required Date: Reference:	1/15/14 1/15/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:			a.			
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:		R		on	२1* २ <i>2</i> *	
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reje Num	Insp. Stamp	

0.00

Memo

160

Quality Control

MUS 14-02-03

DQA:			Date:										TOACL
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPD	DATE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	•					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			moforming	Finishing	4	e/Packaging	Other
NCR I	lo.					Suspected Unapproved			Large Fab	Composite		Supplier	
							•						
Root					Desc	ription of work order update	1	nitial	Action	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Design				:			İ						
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup		}	:										
Process													
Supplier													
Training			ļ										
Transport	H	1											
Unapproved	<u> </u>	<u> </u>		<u> </u>	<u> </u>		FΔI	III T CA	TEGORY		<u> </u>		
Landi	nø (Gear				General	17	OEI CA	ILGON1				
Land	<u> </u>	Bending			Г	Bend	Г]Folio/F	Program	Г	Outside Dim	ensions [Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain	. 06	F	Over/Under		Set-up
	┢	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/Unqu	ualified	Part Lost/Mi		Weld
		Cuffs		•		Contamination	_	1	tions Incomplete/Unc		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d	<u></u>			
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence				

January-15-14 1:12:10 PM

Work Order ID:

111504

Parent Item:

D3575-5

Parent Item Name:

Cargo Floor Protector

Start Date: 1/15/14

Required Date: 1/15/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07.07.23

EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	HEET	Purchased	No			100	sf	3,145.9900	10.666	12		Jmi	4-02-3

Location	Loc Qty	Loc Code	
MAT019	3145.99		
124866	106		
m126425	479.99		
m127934	2560		127934

DQA:			Date:										TRAGG
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	\٨/،	ork Order up	ndate only	AEROSPACE
QA Closeu.			Date.				_				•	·	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
	•					Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	No.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	moforming Finishing		Rec/Sto	re/Packaging	Other
NCR I	۱o.		· · · · · · · ·			Suspected Unapproved			Large Fab Composite		j	Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design		i											
Doc/Data													
Equip/Tooling						:							
Handling/Pre	H										į		
Material	Н												
Operator	\vdash												
Offset/Setup Process	-												
Supplier	Н												
Training							Ì						
Transport													
Unapproved													
							FAI	ULT CA	TEGORY				
Landi	ng (Gear				General							
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	L	Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci _	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	<u></u>	Part Lost/Mi	issing	Weld
	-	Cuffs				Contamination		4	tions Incomplete/Unclear	L	Part Moved	<u> </u>	Wrong Stock Pulled
		Crushing				Countersink	$ldsymbol{ld}}}}}}$	1	gned/off center		Positioned V		7
		Heat Trea				Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other
	L	Inspection		Tube		Drawing	<u> </u>	Misrea					
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes	_	Off-set				 	
	<u> </u>	Turning S	•			Finish	<u></u>	4	Calibration				
1	L	Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	111504
Description: Cabin Floor Protector	Part Number:	D3575-5
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
---	---------------	--	-----------

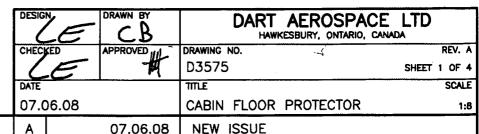
Drawing	7-1	Actual	A 1	Deiset	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø3.00	+0.006/-0.001	3.005"	_		U	JAMOI
3.38	+/-0.030	338*			U	
6.50	+/-0.030	6.50"			· U	
26.13	+/-0.030	30.13"			T	Jemo 6
30.13	+/-0.030	30.13"	_		T	
2.00	+/-0.030	2.00	-		V	
3.50	+/-0.030	3.50"	_		V	
14.25	+/-0.030	14.25"	-		Т	
25.13	+/-0.030	25113			ト	
29.38	+/-0.030	29.39	-		Τ	
30.38	+/-0.030	30.38	_		T	
31.50	+/-0.030	31.50,	_		Τ	
1.00	+/-0.030	1.00"				
4.38	+/-0.030	4.38				
14.50	+/-0.030	14.50				
16.00	+/-0.030	16.00	-			
23.13	+/-0.030	23.13ª	_			
26.88	+/-0.030	⊋6.૬ ₈ ~				
27.69	+/-0.030	27.69"		_		
1.00	+/-0.030	1.00"	_			
3.75	+/-0.030	3.75	-			
9.63	+/-0.030	9.63				
16.13	+/-0.030	16.13"	-			
28.06	+/-0.030	28.06"	_			
32.15	+/-0.030	32.15"	DAS			

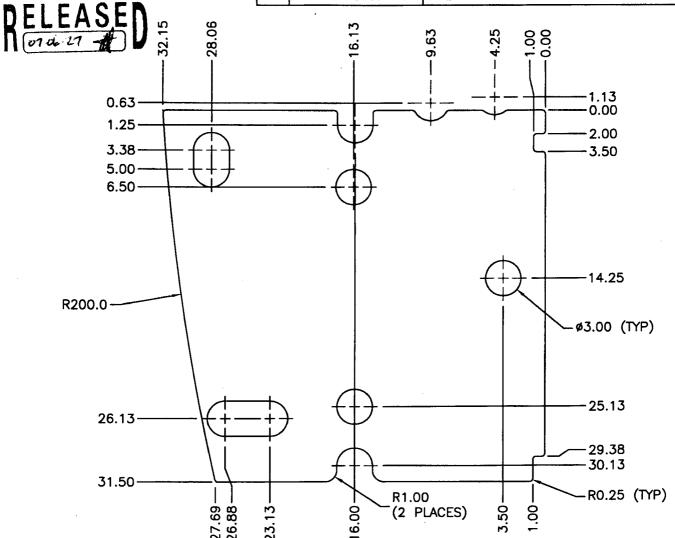
			(U) (U)		
Measured by:	Jm	Audited by:	27 9.80	Prototype Approval:	N/A
Date:	14-02-3	Date:	14.1-3	Date:	N/A

Rev	Date	Change	Revised by,	Approved
Α	08.01.16	New Issue	KJ//DD	

		i . ciisali
		:
2.		
		. *
·		
i k		
편 () ()		
7		
li A		
d.		
•		
		i)







111504 Mt 14.01.16

D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

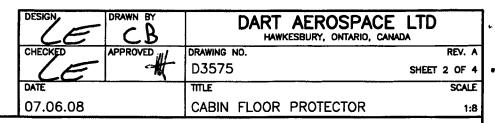
NOTES:

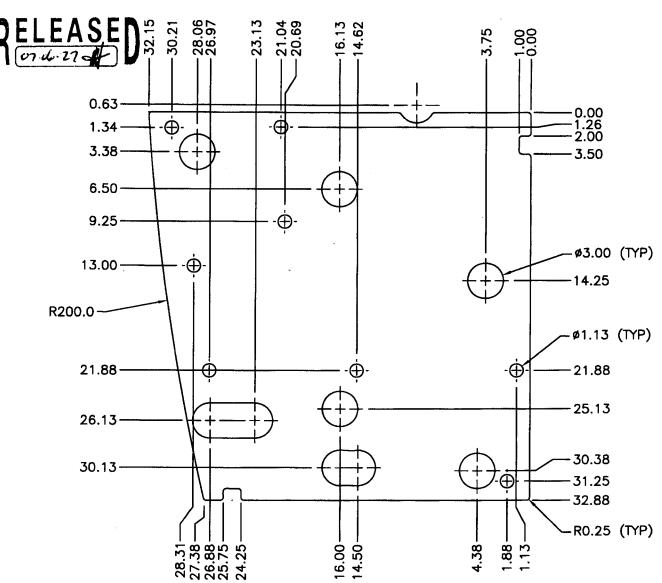
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







D3575-3 CABIN FLOOR PROTECTOR

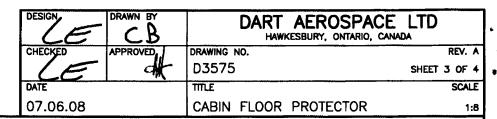
NOTES:

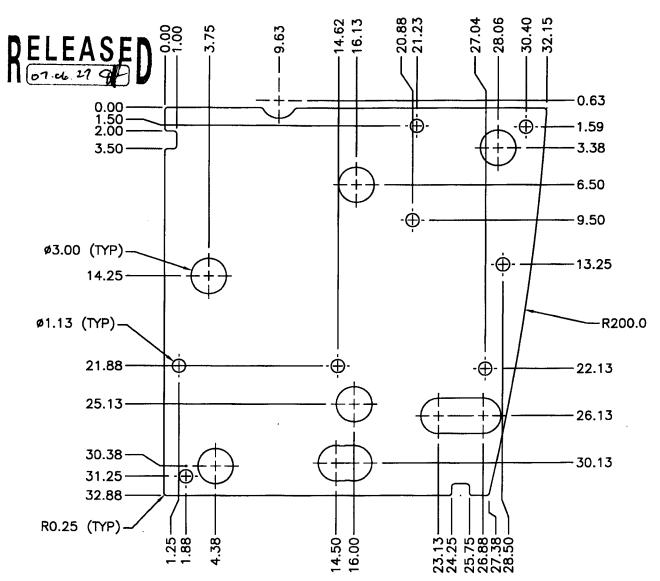
- MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- CHECK PER TEMPLATE DT8967

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







D3575-4 CABIN FLOOR PROTECTOR

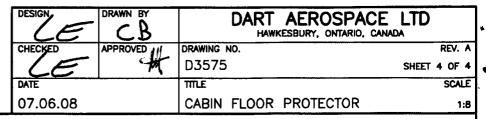
NOTES:

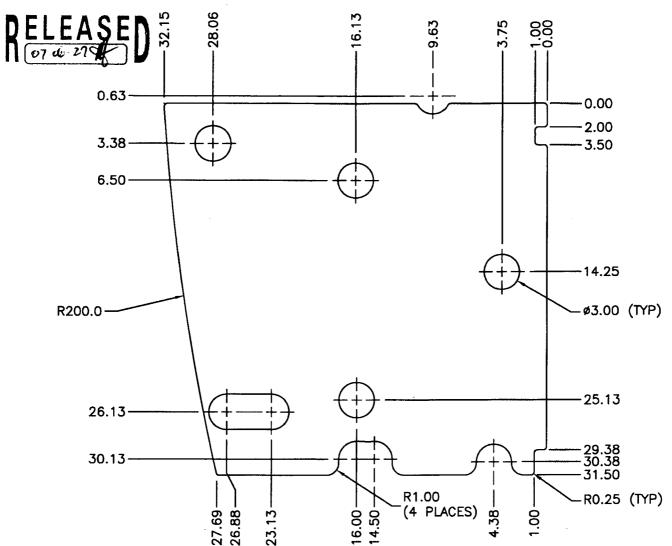
- MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT. IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.